

Work Order ID 85120

85120

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Friday, June 01, 2012 4:05:39 PM

Item ID: PB67-43001-169

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Support Plate

Start Date: 6/1/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *ME* Date: *1206-01* Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001-169

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-6-4

B12-6-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(4)

m/12.06.04

130

Identify as per dwg & Stock Location: 446A 0.00***130***

Packaging

Memo

0.00

Packaging

4x

SP
12-6-5

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/6/57A

m/12-06-05

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Picklist Print

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Work Order ID: 85120

Parent Item: PB67-43001-169

Parent Item Name: Long Support Plate

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-23 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090 6061-T6 .090 Sheet		Purchased	No			100	sf	82.8000	0.5972	2.5145263			

B12-6-4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	82.8	
109184	2	
111382	80.8	

111382

4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

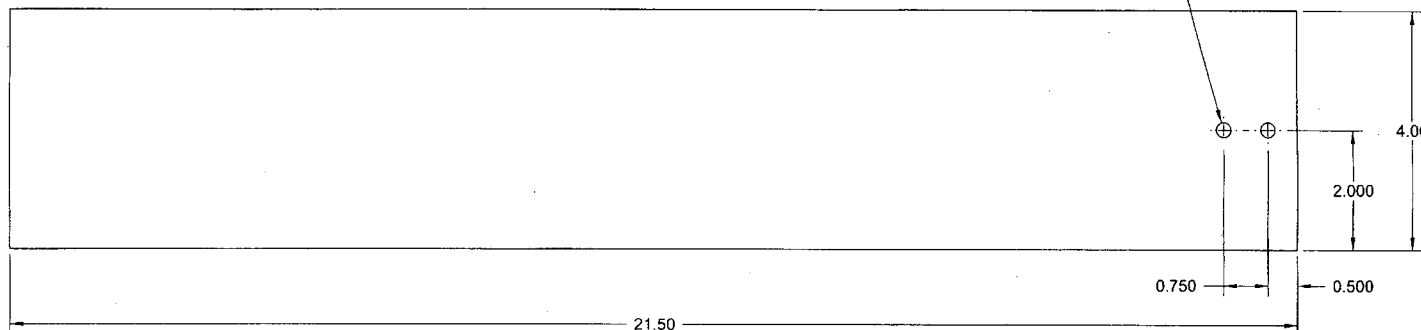
D

C

B

A

0.09
REF



B67-43001-169 LONG SUPPORT PLATE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

85120

RELEASED
2009-09-21
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 27 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.03
REV.	DESCRIPTION		BY	DATE
DESIGN	RW		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RW		DRAWING NO. B67-43001-169	
CHECKED	RW		REV. C	
MFG. APPR.	RW		SHEET 1 OF 1	
APPROVED	RW		SCALE	
DE APPR.	N/A		NTS	
DATE	09.03.03		COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISSEMINATION OF THIS DOCUMENT WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries

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FIRST ARTICLE INSPECTION CHECKLIST

X

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Prototype Approval:	N/A
Date:	N/A

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